

Work Order ID 76852

76852

Page 1

November-22-11 10:54:02 AM

Item ID: D3043-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment LH, A119

Start Date: 22/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/22 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3043

Rev A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G
2-Deburr and bevel ends for welding

110

0.00

110

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802
AR AL ROD Batch: 114514 & 112735
2-Grind Fwd End Cap weld flush

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Hand Finishing

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

76852

November-22-11 10:54:02 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

4

Cust Item ID:

4

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH, A119
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------------|------------------------------|------|--|--|--|--|--|--|--|
| 190 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *190* | HandFinish | 0.00 | | | | | | | |
| Hand Finishing | <i>N/A Memo</i> | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 200 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *200* | HandFinish | 0.00 | | | | | | | |
| Hand Finishing | Memo | | | | | | | | |

| | | | | | | | | | |
|----------------|--|------|--|--|--|--|--|--|--|
| 210 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *210* | Powdercoat | 0.00 | | | | | | | |
| Powder Coating | Memo | | | | | | | | |

START TIME: 7:45
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 8:15

M119480

4X Ø M-L 11/12/19

4X Ø M-L 11/12/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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November-22-11 10:54:02 AM

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Step Weldment LH, A119
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | Wing Walk as per dwg QSI005 4.4 Batch <i>119094</i> | 0.00 | | | | | | | |
| *220* | HandFinish | Memo | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 230 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *230* | QC | Memo | | | | | | | |
| Quality Control | | | | | | | | | |
| 240 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *240* | Packaging | Memo | | | | | | | |
| Packaging | | | | | | | | | |

H. BR 11-12-21

464 d JH 11/12/21
measured & id.

Per 11/22/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76852***76852***

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November-22-11 10:54:02 AM

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment LH, A119
Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 250 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/12/22 *[Signature]*
MF
11-12-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:07 AM

Page 1

Work Order ID: 76852

76852

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C *D2622-120C* Step Extrusion | | Manufactured | No | | | 100 | Each | 28.0200 | 1 | 4 | | 11.12.01 | |

**

| Location | Loc Qty | Loc Code |
|-------------|---------|----------|
| HALL B75781 | 18.32 | |
| 64409 | 6 | |
| 68293 | 0.5 | |
| 72131 | 11.82 | |
| WA | 9.7 | |
| 46910 | 2 | |
| 66970 | 7.7 | |

D3040-3

Manufactured No

100

Each

14.0000

2

8

D3040-3

Mounting Lug

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA018 | 14 | |
| 48240 | 14 | |

D2734

Manufactured No

120

Each

41.0000

1

4

D2734

Step End Plate

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 41 | |
| 73416 | 41 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 2

November-22-11 10:54:07 AM

Work Order ID: 76852

76852

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

D3040-1 Manufactured No

120 Each 18.0000 2 8

D3040-1

Mounting Lug

**

11.12.12

Location

Loc Qty

Loc Code

WA018

18

48239

18

8

D2734 Manufactured No

160 Each 41.0000 1 4

D2734

Step End Plate

**

11.12.13

Location

Loc Qty

Loc Code

WA

41

73416

41

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3043 | REV. A SHEET 1 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE NTS |
| A | 01.06.28 | NEW ISSUE | |

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------|
| X | | D3043-041 | STEP WELDMENT, LH |
| | X | D3043-042 | STEP WELDMENT, RH |
| | | | |
| 1 | 1 | D2622-120 | STEP EXTRUSION |
| 2 | 2 | D3040-1 | MOUNTING LUG |
| 2 | 2 | D3040-3 | MOUNTING LUG |
| 2 | 2 | D2734 | ENDPLATE |
| | | | |

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76852 M.L.J
11/11/22

RELEASED
01.07.05 *[Signature]*

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

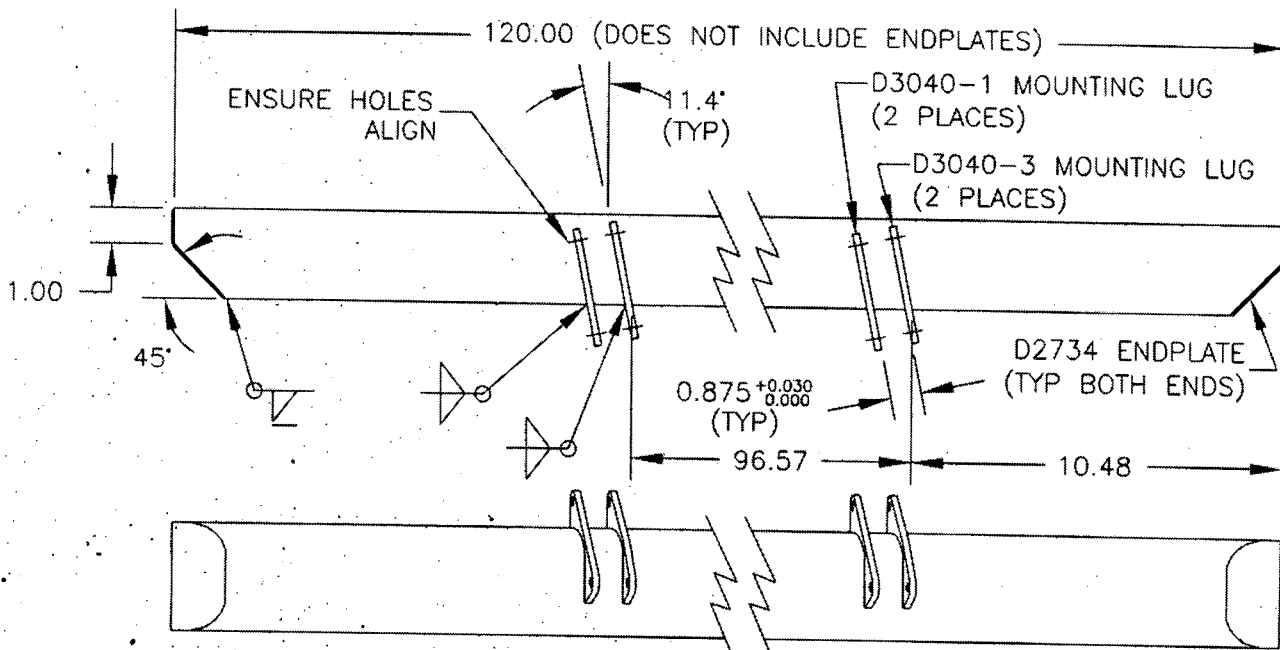
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NOTE: Date & initial all entries

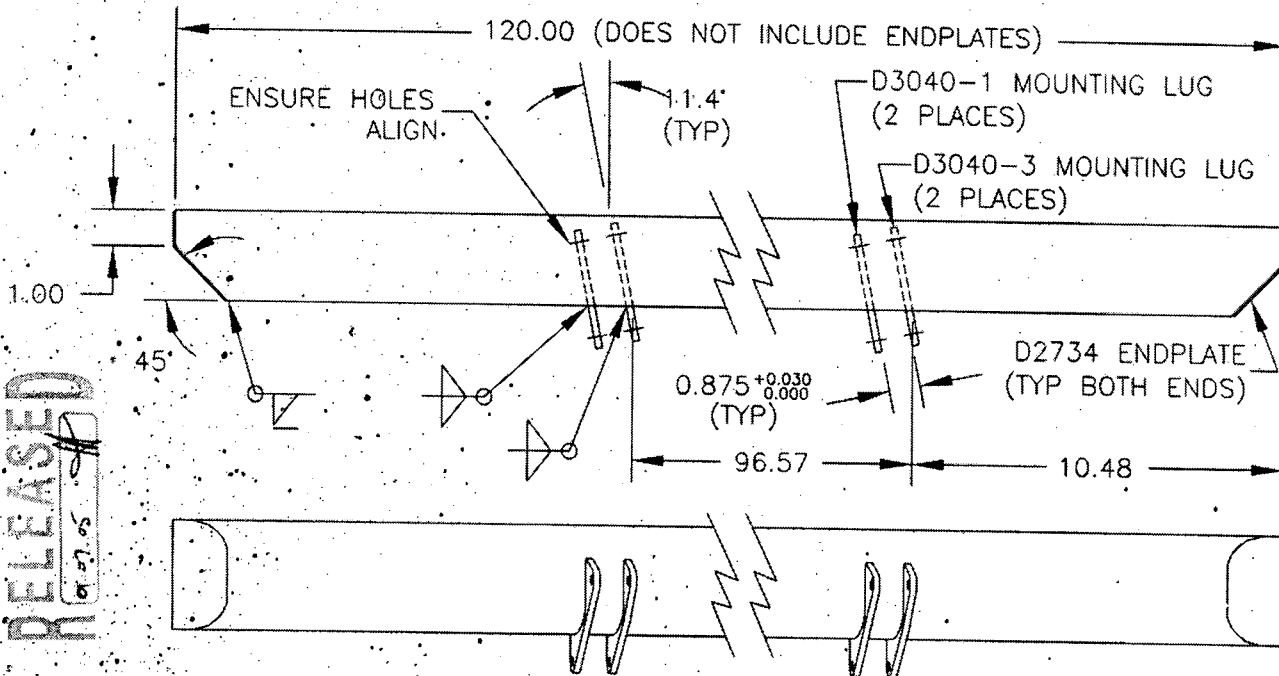
76852



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|------------------|----------------|--|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED # | APPROVED # | DRAWING NO. D3043 | REV. A SHEET 2 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE 1:5 |
| A | 01.06.28 | NEW ISSUE | |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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RELEASED
So. Co. 10

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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